

Garant
Diabolo carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 12/1,5 mm

Order data

Order number	206342 12/1,5
GTIN	4045197598974
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide, specially for hard machining.

Double relief ground side clearance angle.

Tolerance: Corner radius $R_1 = \pm 0.005 \text{ mm}$.

No. of teeth Z: 4

Helix angle: 30 degrees

Shank: DIN 6535 HA to h6

No. of teeth Z: 4

Flute length L_c : 12 mm

Corner radius R_1 : 1.5 mm

Overhang length L_1 incl. recess: 75 mm

Recess $\varnothing D_1$: 11 mm

Overall length L: 120 mm

Technical description

Recess $\varnothing D_1$	11 mm
Feed f_z for copy milling in steel < 65 HRC	0.08 mm
Cutting edge $\varnothing D_c$	12 mm
Corner radius R_1	1.5 mm
No. of teeth Z	4
Feed f_z for side milling in steel < 65 HRC	0.08 mm
Overhang length L_1 incl. recess	75 mm

Shank $\varnothing D_s$	12 mm
Flute length L_c	12 mm
Overall length L	120 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	e8
Spacing of the cutters	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Cutting width a_e for milling operation	0.2×D for side milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	red
Type of product	End mill

Services

Shank recess Type FRST	209900 FRST
Shank clamping flats for shrink-fit chucks, with retainer function Shank \varnothing tool 12 mm	SZ2025 12
Shank grinding Type HB	129100 HB